



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5355-041
Job Sheet 180050



Part No: D5355-041

Job Qty: 4 ea

Part Name: Aft Clamp Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	4 pcs	7/13/18	7/13/18	0.00	0.02	Bandsaw1		
110	CNC Vertical Machining	4 pcs	7/13/18	7/13/18	1.21	1.71	HAAS 5 Axis		
120	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC8 Machining-4		
140	Outsource	4 pcs	7/13/18	7/13/18			ATG001-VC	10	
150	Packaging	4 pcs	7/13/18	7/13/18	0.00	0.00	Packaging2		
155	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC5		
160	Small Fab	4 pcs	7/13/18	7/13/18	0.00	0.81	Small Fab-9		
170	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC5		
180	Packaging	4 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		
190	QC21-SA	4 Ea	7/13/18	7/13/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 6.200"

Descriptions: 110 - 1-Machine per folio FB434 DWG REV: C FOLIO REV: 14 2- deburr and break all sharp edge as per dwg

140 - Issue P/O to ATG : 040641 Black Anodize as per Dwg D5355 Certification of Conformity is required.

150 - Certification of Conformity is required.

160 - Assemble as per dwg. -Secure nuts as per dwg. (Note #8) -Apply proseal as per dwg.(Note #9)

Batch: S080715 Exp. date: may 01-19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X04.500	6061-T6 Bar 1.25 X 4.50	2.0680 ft (.517 ea)	90-Start up Operation	<u>S097229</u>
D5316-1	T-Bolt Strap	4 Ea (1 ea)	160-Small Fab	<u>S030374</u>
D5351-1 <u>CA132</u>	T-Bolt Spacer	8 Ea (2 ea)	160-Small Fab	<u>S097122</u>
MS21043-3	Nut	8 Ea (2 ea)	160-Small Fab	<u>S083543-1</u>
NAS1149D0332J	Washer	8 Ea (2 ea)	160-Small Fab	<u>S100407</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.250X04.500	2	8	0
160-Small Fab	D5316-1	4	14	0
	D5351-1	8	1	0
	MS21043-3	8	1,175	0
	NAS1149D0332J	8	1,561	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Part Specifications

Specifications could not be found.

Plex 6/28/18 9:44 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S097230
Part: D5355 - 041
Job No: 180050
Serial No/Batch: S097230
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/29/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order:	18005C
Description:		Part Number:	D5355-041
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	.997	✓		SLIO	Vern
.50	+/- .030	.496	✓			
Ø .204	+ .005 / - .001	.205	✓		↓	
.22	+/- .030	.220	✓		↓	
.274	+/- .010	.274	✓		↓	
R.13	+/- .030	.130	✓		Rad gauge	
R.987	+/- .010	.987	✓		"	
R.20	+/- .030	.20	✓		"	
20°	+/- .5°	20°	✓		Protractor	
10°	+/- .5°	10°	✓		"	
.56	+/- .030	.560	✓		SLIO	Vern
.40	+/- .030	.388	✓		↓	
.21	+/- .030	.230	✓			
R.40	+/- .030	.400	✓		Rad gauge	
.13	+/- .030	.122	✓		SLIO	Vern
R.29	+/- .030	.290	✓		Rad gauge	
.15	+/- .030	.147	✓		SLIO	Vern
1.28	+/- .030	1.275	✓		↓	
.13	+/- .030	.110	✓			
R.25	+/- .030	.250	✓		Rad gauge	
1.20	+/- .030	1.200	✓		↓	
2.00	+/- .030	1.980	✓			
.40	+/- .030	.386	✓			
.50	+/- .030	.486	✓			
.500	+/- .010	.500	✓			
Ø .257	+ .005 / - .001	.258	✓			
5.01	+/- .030	5.000	✓			
R.30	+/- .030	.300	✓			
.30	+/- .030	.275	✓		↓	

Measured by:	20 9-89	Checked by:	A.P.	QC Inspector:	
Date:	18-07-29	Date:	18-07-30	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040641

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040641
PO Date: 7/30/18
Due Date: 8/8/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178875	C45-8-5	Solenoid Cover -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/8/18	20 pcs	0 pcs	20 pcs	\$8.20/pcs	\$164.00
2	180050	D5355-041	Aft Clamp Assembly : Various STC's Issue P/O to ATG : Black Anodize as per Dwg D5355 Certification of Conformity is required.	Firmed	-	8/8/18	4 pcs	0 pcs	4 pcs	\$6.45/pcs	\$25.80
3	181174	647.0310	Channel Issue P/O to ATG : Hard Anodize Black / Prime as per Dwg 647.0300	Firmed	-	8/16/18	20 pcs	0 pcs	20 pcs	\$14.30/pcs	\$286.00

Line Item Note ** urgent **

Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
4	181151	RBD29904	Hoist Adapter "D" Model -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	8/8/18	3 pcs	0 pcs	3 pcs	\$28.20/pcs	\$84.60	
Grand Total:											\$560.40	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/3/18 10:33 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915738

Date: 03-Aug-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chris oula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: C45-8-5 ✓ Solenoid Cover Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 23528	Rev: 10 PO: PO040641 Line: 1	
3 ea	Part: RBD29904 ✓ Hoist Adapter "D" Model Red anodize per MIL-A-8625 Type 2 Class 2 (as per e-mail from Michael Lee) Job: 23533	Rev: PO: PO040641 Line: 2	
4 ea	Part: D5355-041 ✓ Aft Clamp Assembly Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils) Job: 23532	Rev: C PO: PO040641 Line: 3	DAS 61 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>03/08/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.